

REBATE



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-31702W23-7

Job Sheet 184999



Part No: RBE105-31702W23-7

Job Qty: 2 pcs

Part Name: Measuring Flange RH Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31702W23 Rev.1 IPP Rev. A 18.10.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Small Fab - 1	2 pcs	11/30/18		0.00	2.00	Small Fab - 1	
							Small Fab - 2	MLC
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
120	QC 5	2 pcs	11/30/18		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	DAS
							QC 5 - 38	38
							QC 5 - 42	9-89
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
130	Outsource - 13 - Zinc Plating	2 pcs	11/30/18		0.00	0.00		
140	Packaging 2-1 - Receive - B4B	2 pcs	11/30/18		0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	

Plex 1/23/19 3:16 PM dart.leclair.mathieu



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S147431



Part: RBE105-31702W23-7

Job No: 184999

Serial No/Batch: S147431

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 01/23/19

				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
180	QC 6	2 pcs	11/30/18	0.00 0.00	QC 6 - 38
					QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
190	Packaging 3-1 - Stock - B4B	2 pcs	11/30/18	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B

FEB 07 2019
DAS
68
9-89

DAS
28
9-89

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	2 pcs	11/30/18	0.00 0.00	QC 21 - SA - 21	DAN 21 3-85
				QC 21 - SA - 70	FEB 07 2019

Part Op 110 - (Small Fab) 1-Assemble as per DWG.
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - Issue P/O to GROUPE ALTECH: P/O 042400 - Zinc plate, ASTM-B633 TYPE 1 SC2 - Color: Clear -Material type; 4140 -Certificate of Conformity is required
 140 - (Receive & Inspect for Damage & Mat'l Certs)
 180 - (QC6- All purchased or subcontracted products)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Black oxide
part is actually Zinc per drawing.
JAN 23/19

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
91595A112	Dowel Pin ØM3 x 12mm	8 Ea (4 ea)	110-Small Fab - 1	3122134
RBE105-31702W23-11	Measuring Flange Plate RH	2 Ea (1 ea)	110-Small Fab - 1	3140101

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	91595A112	8	121	8

Allocated Container Detail			
Qty	Container No	Location	Init
8	S147394	ga051	_____
	RBE105-31702W23-11	2	8
			2

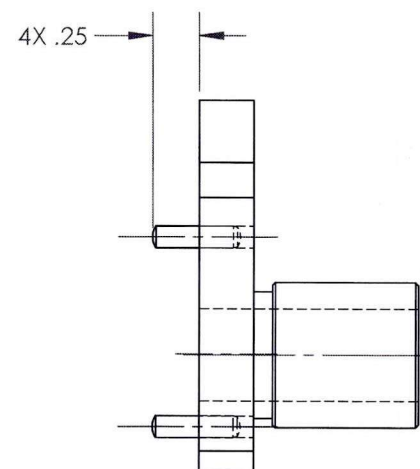
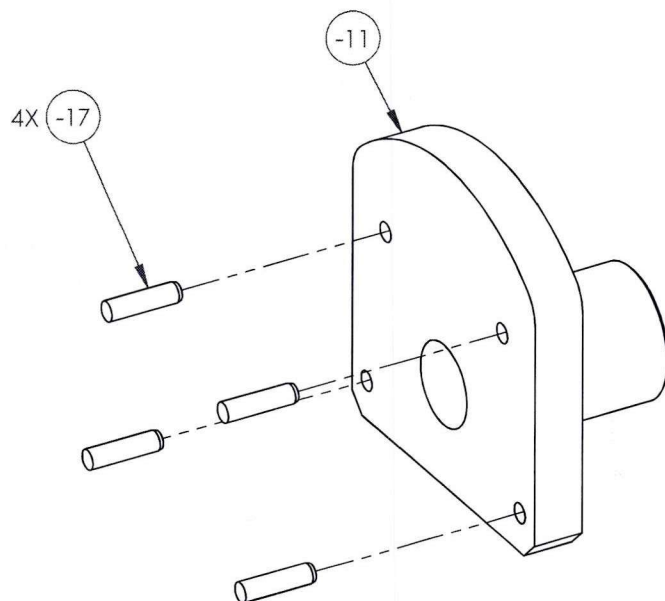
Allocated Container Detail			
Qty	Container No	Location	Init
2	S147430	ga134	_____

Part Specifications	
Specifications could not be found.	

Plex 1/23/19 3:16 PM dart.leclair.mathieu

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



-7
MEASURING FLANGE RH ASSEMBLY

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W23-7	REV 1
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 1/18/2016
SHEET 5 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042400



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042400
PO Date: 1/25/19
Due Date: 1/28/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments: Is it possible to have these for Monday?
Please advise**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184999	RBE105-31702W23-7	Measuring Flange RH Assembly -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed	-	1/28/19	2 pcs	0 pcs	2 pcs	\$15.00/pcs	\$30.00
2	187488	RBW109-3101-75-101	Wrench, Flight Controls Servo Actuator Joint Removal/Installation -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	1/28/19	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00
3	187057	RBBP-1404-1-3	Weldment -Issue P/O ; -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	1/28/19	4 pcs	0 pcs	4 pcs	\$15.00/pcs	\$60.00
Grand Total:											\$180.00

JAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042400



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Certificat de Conformité / Certificate of Compliance

(016311-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016311- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
29-Jan-2019		Jessie Boisvert		042400 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE105-31702W23-7 ✓ Rev.	RBE105-31702W23-7 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	2	2 ✓	0	0	0
2	RBW109-3101-75-101 ✓ Rev.	RBW109-3101-75-101 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	6	6 ✓	0	0	0
3	RBBP-1404-1-3 ✓ Rev.	RBBP-1404-1-3 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	4	4 ✓	0	0	0

Notes Additionnelles / Additional Notes

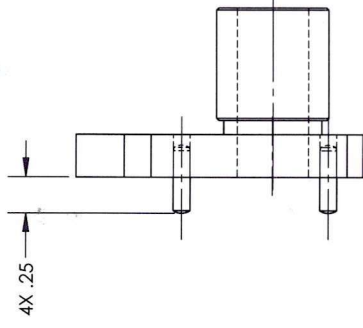
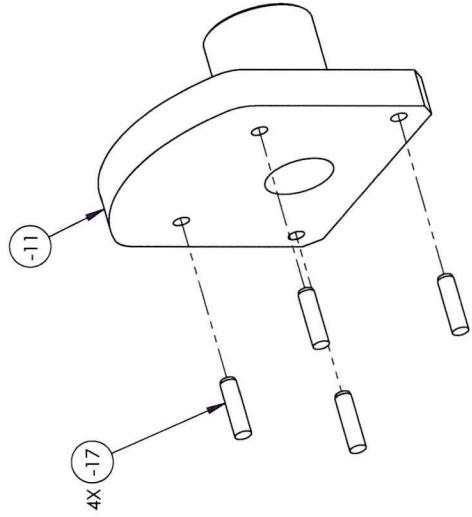
Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

This drawing, specifications, and concepts contained herein are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Engine, OR.

REV		ECR	REVISIONS		DESCRIPTION	DATE	INITIAL	APPROVED



MEASURING DEVICE

TITLE		REV
MEASURING DEVICE		1
DWG NO.	RBE105-31702W23-7	
MAT'L	UNLESS OTHERWISE SPECIFIED	
HEAT TREAT	DIMENSIONS ARE IN INCHES	
FINISH	XXX ± .008 FRACTIONS ± 1/8	
SPEC	XX ± .01 ANGLES ± .1	
DRAWN BY:	X ± .1 SURFACES ± 1/8	
CHECKED:	1. BREAK ALL SHARP EDGES	
OPPS APPR:	2. .015 x 45° OR .016R	
QA APPR:	3. INTERPRET DIM AND TOL PER	
APPROVED:	ASME Y14.5-2009	
SCALE	USED ON MODEL	
1:1	ECT145	
DATE	1/18/2016	
SHEET 5 OF 9		

MEASURING FLANGE RH ASSEMBLY